

Work Order ID 68008

Tuesday, April 05, 2011 10:52:48 AM



Page 1

Item ID: D4323-23

Accept



Setup Start



Revision ID: PRELIM

Item Name: Access Panel, LH

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

PRELIMINARY ISSUE

Reference:

Run Start



Approvals: Process Plan: *MF*

Date: *11-04-05* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4323

PAT PA8 BB

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 11/04/05

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

Temp: *140 - 150°*

Time IN: *6:00 PM 11/04/05*

Time OUT: *7:00 AM 11/04/05*

BB 11/04/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform	0.00							
	Thermoforming Machine								
	Memo	0.00							
	1-Machine Set-Up								
	2-Pre-heat Tool to required temp.								
	3-Thermoform as per Dwg and Folio #FTA107 using tool DT9733								
	Dwg Rev: <u>PAS</u>								
	Folio Rev: <u>A</u>								
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Quality Control								
	Memo	0.00							
	Visually inspect part for proper formation and texture								
130 	QC8- Inspect parts - second check	0.00							
	QC								
	Quality Control								
	Memo	0.00							

11/04/05

11/04/05

11/04/05

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Work Order ID 68008

Tuesday, April 05, 2011 10:52:48 AM



Page 4

Item ID: D4323-23

Accept



Setup Start



Revision ID: PRELIM

Item Name: Access Panel, LH

Stop



Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: *Recall*

0.00



Packaging

Memo

0.00

Packaging

Recall 4/6 *(1)*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD 2370

POSITIVE RECALL

EFFECTIVE *5/10/08*

AUTH *MF*

11-04-06

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:52:45 AM

Page 1

Work Order ID: 68008



Parent Item: D4323-23



Parent Item Name: Access Panel, LH

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: RIPP RevA New Issue 11-03-01 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	3.46875			



6185 KYDEX .080"



Location

therm

Loc Qty

787.2912

787.2912

Loc Code

16576

3,468.75 sq ft.

DL
4/04/06

W/O:		WORK ORDER CHANGES						
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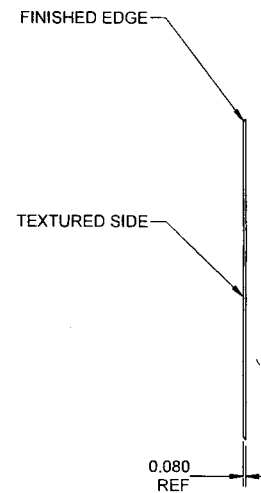
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NOTE: Date & initial all entries

D4323-23 ACCESS PANEL, LH
D4323-24 ACCESS PANEL, RH (OPPOSITE)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.68 lb
- 8) TOOLING: THERMOFORM -23/-24 PART PER MOLD DTXXXX.
TRIM PER MOLD LEAVING FINISHED EDGE
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040



68008

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED		DRAWING NO.	REV. PA8
MFG. APPR.		D4323	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SURPLUS ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	68008
Description: ACCESS PANEL LH		Part Number:	4323-23
Inspection Dwg: 4323	Rev: PA8	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>JB</u>	Date: <u>11/04/05</u>
------------------------	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.00"	±0.030	18.175	✓		TH 05	
10.58"	±0.030"	10.55	✓		TH 03	
9.78"	±0.030"	9.78	✓		TH-03	

Measured by: <u>JB</u>	Date: <u>11/04/05</u>
Audited by: <u>S b Pat Day</u>	Date: <u>11/24/06</u>
Preliminary Approval: <u> </u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Saturday, April 02, 2011 5:44 PM
To: 'Daryl Leger'
Cc: 'Eric Charbonneau'; 'JEANLUC MENARD'; 'Linda Lacelle'; Bill Beckett; 'Harvey Siemens';
'David Shepherd'
Subject: D4380 Issues

Hi Daryl,

Please see D4380-PA6 in the Prelim folder.

Fortunately, the guys were still here and I talked to them about the manufacturing issues.

Based on their feedback, I have modified the D4380-17 cover. It should be a little easier to manufacture.

However, the -3/-5/-27/-29 need to stay as they are. Please use the "cheat the corners" technique to make the part as true to the drawing as possible. There are spare air conditioning vents here – we could fedex you one on Monday if that would help in creating the moulds.

The only thing I changed in the PA6 rev was the -17.

As for cutting out the "tops" of the round parts (-21/-23/-25 etc), it is up to you. If you would like to cut it out and trim it, that's ok, or the guys here can do that.

Thanks Daryl,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325

F: 403-717-1288

E: dcampbell@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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